

Work Order ID 115523

April-02-14 3:07:11 PM

115523

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Item ID: D4034-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Rib
 Start Date: 4/02/14 Start Qty: 12.00 *12* Cust Item ID:
 Required Date: 4/16/14 Req'd Qty: 12.00 *12* Customer:
 Reference:

Approvals: Process Plan: MLS Date: 170402 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4034	C

100 0.00

100

Large Fab Memo 0.00
 Large Fab 1- Cut tube as per dwg D4034

12X CC / DC 14-4-2

110 QC6- Inspect dimensions to drawing 0.00

110

QC Memo 0.00
 Quality Control

12 14.4.4 DAS 24 9-88

120 Identify as per dwg & Stock Location: WA004 0.00

120

Packaging Memo 0.00
 Packaging

12 14.4.4 DAS 24 9-88

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Item ID: D4034-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Rib

Start Date: 4/02/14 Start Qty: 12.00 *12*

Cust Item ID:

Required Date: 4/16/14 Req'd Qty: 12.00 *12*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130	QC21- Final Inspection - Work Order Release	0.00							
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130

QC

Memo

0.00

Quality Control

14-04-4

1404-4

Picklist Print

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Work Order ID: 115523

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Parent Item: D4034-1

D4034-1

Parent Item Name: Rib

Start Date: 4/02/14

Required Date: 4/16/14

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP RevA: new issue DD 09.11.23 verified by:EC IPP Rev:B as
per dwg revA 10.03.15 verified by:EC IPP Rev:C 11.01.18 chg
qc5 to 6 DD verf:EC IPP Rev:D 11.01.19 AS PER DWG
REV.B DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304TS0.750W.049 Purchased

No

100 f

1,136.661 0.3333 5

M304TS0 750W 049

304 SQ Tube .75x.75x.049W

CC / DC 14-4-3

Location

Loc Qty

Loc Code

WA004

1136.661053

M126039

27.625

M126364

50.875

M127493

420

M127821

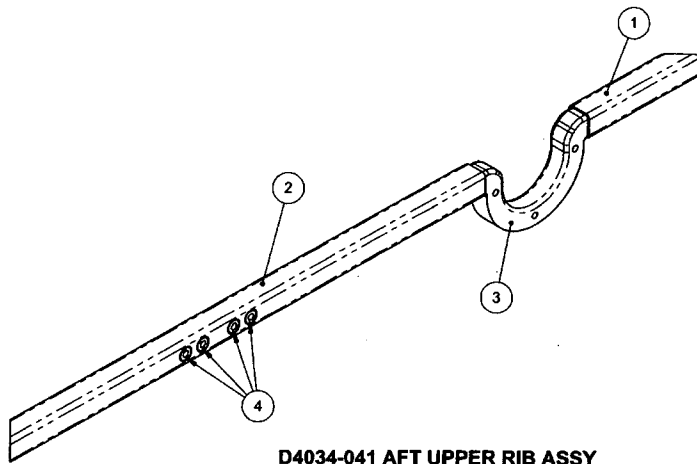
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M128414

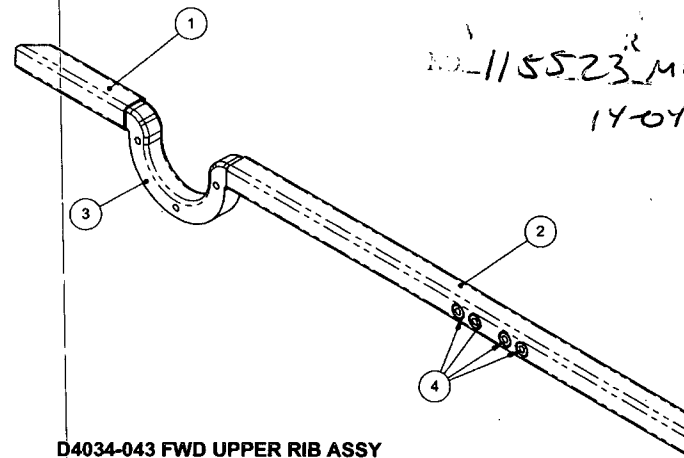
555

~~297~~ 29

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4034-041	AFT UPPER RIB ASSY
		X	D4034-043	FWD UPPER RIB ASSY
1	1	1	D4034-1	RIB
2	1	1	D4034-3	RIB
3	1	1	D4021-7	HOOP
4	4	4	D4021-9	BUSHING



D4034-041 AFT UPPER RIB ASSY

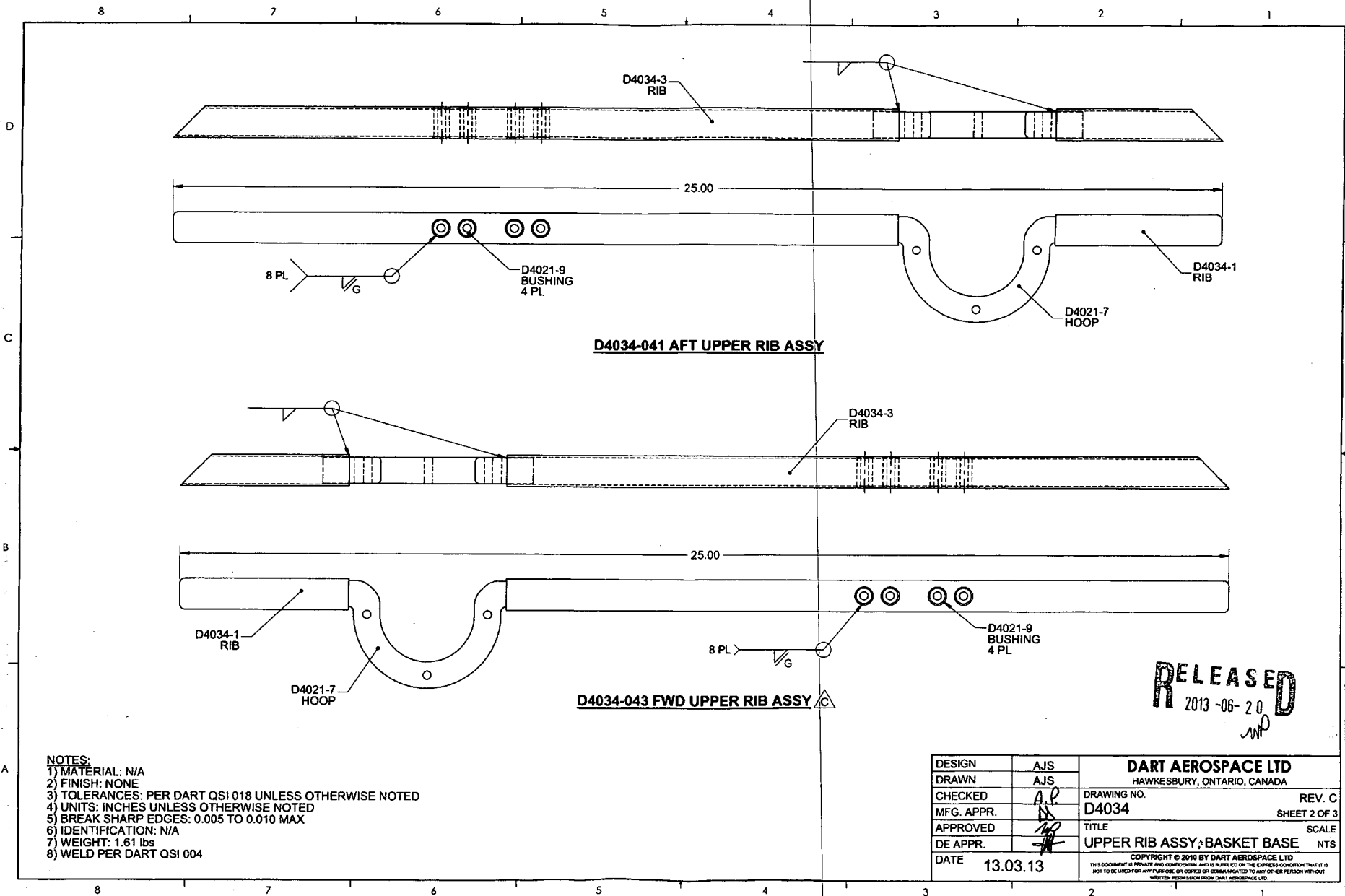


D4034-043 FWD UPPER RIB ASSY

10-115523 ML5
1404-02

RELEASED
2013-06-20

C	-043 REDESIGNED AS MIRROR IMAGE OF -041. -5 DELETED. D2327-3 DELETED. REASON PROP ARM NO LONGER OFFERED.	AJS	13.03.13
B	ADDITIONAL HOLES ADDED ON D4034-3 RIB	SC	10.12.20
A	NEW ISSUE	AJS	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	A.P.	DRAWING NO.	REV. C
MFG. APPR.	IS	D4034	SHEET 1 OF 3
APPROVED	12	TITLE	SCALE
DE APPR.	12	UPPER RIB ASSY, BASKET BASE	NTS
DATE	13.03.13	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.61 lbs
 - 8) WELD PER DART QSI 004

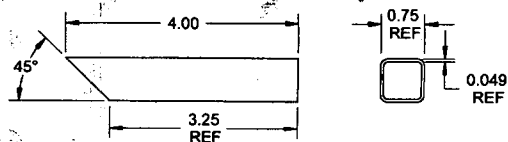
D4034-043 FWD UPPER RIB ASSY

D4034-041 AFT UPPER RIB ASSY

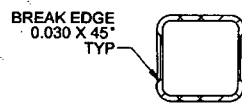
RELEASED
2013-06-20

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	AP	DRAWING NO.	REV. C
MFG. APPR.	IS	D4034	SHEET 2 OF 3
APPROVED	AP	TITLE	SCALE
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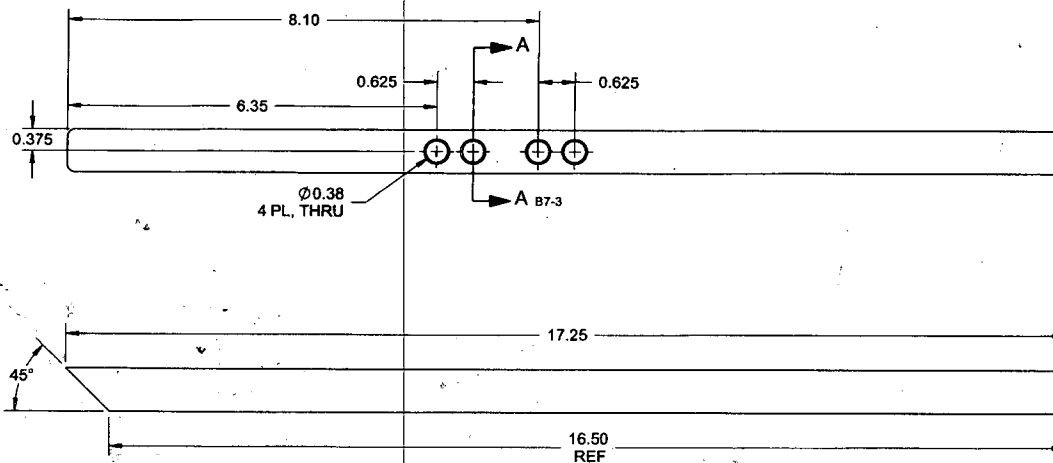




D4034-1 RIB



SECTION A-A *C3-3



D4034-3 RIB

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -1: 0.13 lbs
-3: 0.62 lbs

RELEASED
2013-06-28

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	A.P.	DRAWING NO.	REV. C
MFG. APPR.	DS	D4034	SHEET 3 OF 3
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	UPPER RIB ASSY, BASKET BASE	NTS
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